

Work Order ID 73980

Tuesday, September 20, 2011 10:23:44 AM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *ME* Date: *11-09-29* Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D206-559	rev L
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

W 11 11 29 (6)
MLIS 11-11-29 (6)

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/11/28 (6)

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W 11 11 29 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73980

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Item ID: D206-559-013

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-013 Location: <u> </u>								
	<i>New B</i>								
190		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

*9/20/11 9 (6)**11/11/29**11-11-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:23:41 AM

Page 1

Work Order ID: 73980

Parent Item: D206-559-013

Parent Item Name: Bearpaw



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: J 04.02.17 Blank size changed KJ/JLM
 IPP Rev: K 07-01-02 Was K10008 JLM
 IPP Rev: L 08-01-09 Added Step 2 JLM Verified By: EC
 IPP Rev: M 08-04-29 update seq. 8 and 12 DD verified by: EC
 IPP Rev: N 08-10-15 New Manufacturing Method JLM Verified
 By: EC IPP Rev G 10.10.04 per DS19527 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty.	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	---------------	----------------	--------

AN4-17A Bolt		Purchased	No			160	Each	489.0000	12	72			
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST358	189	
116419	0	
116704	0	
117514	89	
117619	100	

ST359	300	
118628	300	

AN4-20A Bolt		Purchased	No			160	Each	478.0000	12	72			
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST359	478	
116419	178	
117514	300	

AN960JD416 Washer	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	144			
----------------------	---------------	-----------	----	--	--	-----	------	--------	----	-----	--	--	--

117619 4x
118628 68x

117514
119097

4/11/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, September 20, 2011 10:23:41 AM

Work Order ID: 73980

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 6.00

Required Qty: 6.00

D2182B Manufactured No 160 f 73.5212 2.5 15



Rubber Cushion



73932

[Handwritten signature]

Location

Loc Qty

Loc Code

ST410

73.52117

66063

73.52117

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No 160 Each 644.0000



Radius Block



72

[Handwritten signature]

Location

Loc Qty

Loc Code

ST010

243

69736

9

73389

234

ST011

401

72121

401

73389

D2432 Manufactured No 160 Each 1.0000



206 (24") Bearpaw



12

73981 11x

[Handwritten signature]

Location

Loc Qty

Loc Code

ST017

1

69653

1

D2438 Manufactured No 160 Each 309.0000



Clamp



36

69653 1x

[Handwritten signature] 11/11/28 (6)

Location

Loc Qty

Loc Code

ST456

309

69737

108

70693

1

73400

200

73400

Tuesday, September 20, 2011 10:23:41 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Tuesday, September 20, 2011 10:23:42 AM

Work Order ID: 73980

Parent Item: D206-559-013

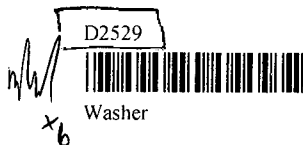
Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 6.00

Required Qty: 6.00



Manufactured No

160 Each

647.0000

12

72

[Signature]

Location

Loc Qty

Loc Code

ST016

647

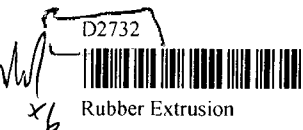
71161

250

73486

397

73786



Manufactured No

160 f

521.8981

2.5

15

[Signature]

Location

Loc Qty

Loc Code

ST410

521.89811

64283

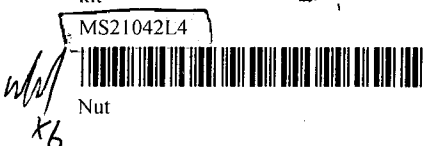
23.02811

70987

498.87

70987

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***



Purchased No

160 Each

4,309.000

12

72

119017 10/11/28(6)

Location

Loc Qty

Loc Code

ST300

4309

117441

51

117601

637

117885

621

118451

2000

118927

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D206-559
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION I
8	12	8	12			16	D2274	RADIUS BLOCK I
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW I
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP I
8	12	8	12				D2529	WASHER I
	6		6				D2732-050	RUBBER CUSHION I
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT I
8	12	8	12	8	12		AN4-20A	BOLT I
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: L
Date: 11.04.08